

Date: Monday, 11/05/2009 3:13:08 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47891
 Estimate Number : 13930
 P.O. Number :
 This Issue : 11/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : MF 09-05-11
 Comment : Est Rev: A 09-05-11 new issue EC verified by: DB

Drawing Name : BRACKET
 Part Number : D39421
 Drawing Number : D3942 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 13/05/2009 Qty: 7 Um: Each

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 0.0158 sf(s)/Unit Total : 0.1103 sf(s)

304/316 .050 Sheet

Batch: 100156 B 9-5-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3942-1

Dwg Rev: PROTO

Prog Rev: TYPE

B 9-5-11

2-Deburr if necessary

M-F 09/05/12

(10)

(10X)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING
APPROVAL

09-05-12 (10)



(PTC)

last page

Comment: SECOND CHECK

5.0 BRAKING NC BRAKE



Comment: NC BRAKE

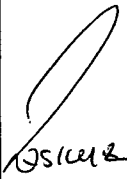

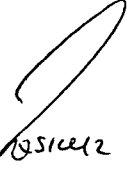
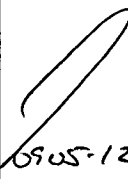
Send as per dwg D3942

09/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3942-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47891</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.05.12	2.0	The 0.129" holes are 0.130 on one side, but close to the taper are 0.126" on the bottom side. RC: W.J. taper.		drill hole open as per dwg to 0.129; debur tabs.	M.A. 09/05/12	 09.05.12		

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 3:13:08 PM
Us Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47891

Part Number: D39421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



PH 09-05-12 **ENGINEERING APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify as per dwg and Stock
Location: _____

*Send to H. Siemens
in Calgary PH 09-05-12*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



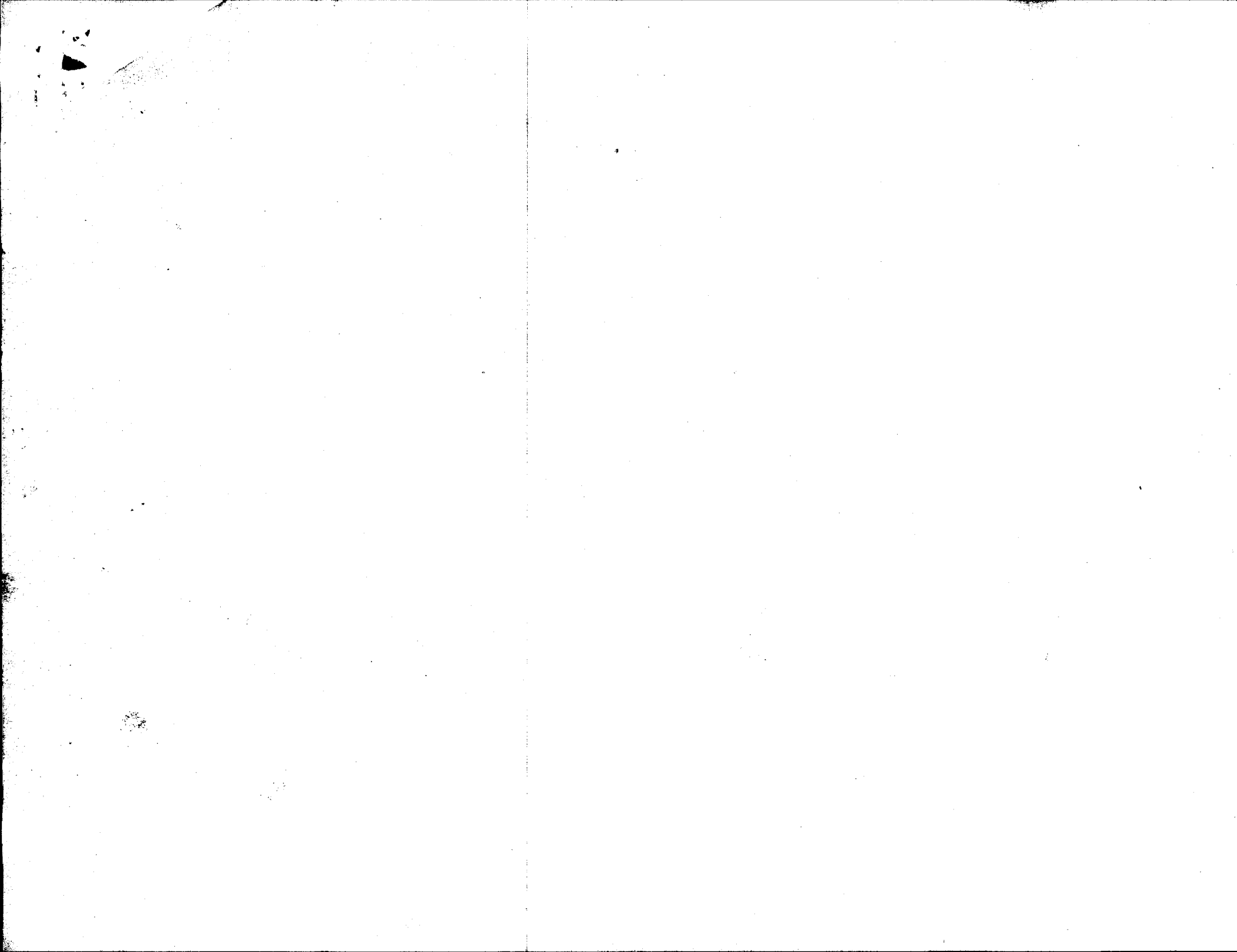
09/05/12 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

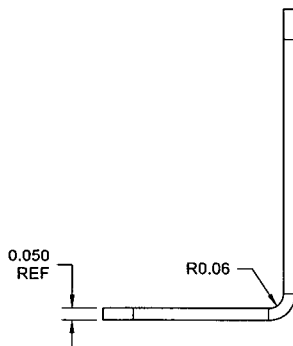
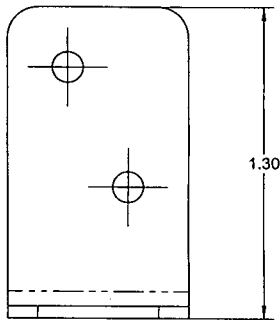
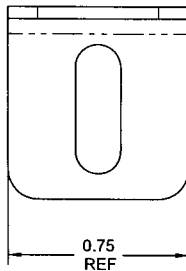
Job Completion



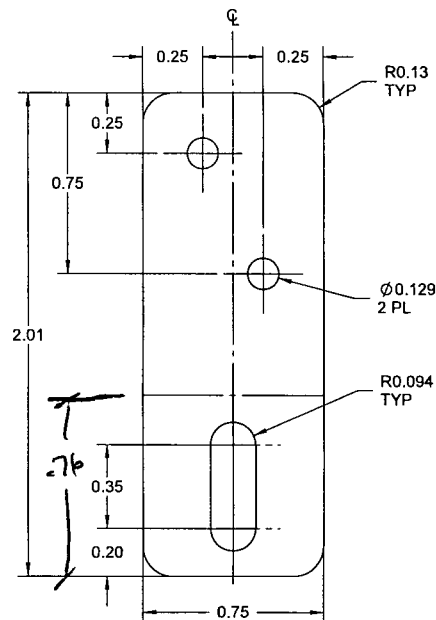
*changed to 00279A
MP 09-05-12*



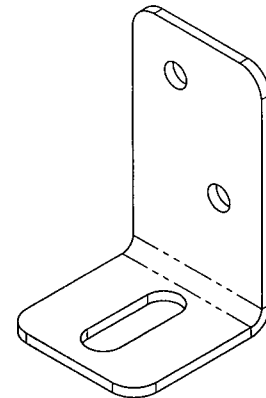
PRELIMINARY ISSUE
09/05/11



D3942-1 ANGLE
MADE FROM D3942-1F



D3942-1F FLAT PATTERN



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		09.05.06	
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3942 TITLE BRACKET			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	09.05.06	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			